Work	Order	ID	<b>7220</b> :
Monday	August 20	2011	10.44.

4:56 AM

Page 1

Item ID:

D3463-041

Accept

Setup Start

**Revision ID:** Item Name:

**Start Date:** 

Approvals:

Step Weldment Assembly

Start Qty: \2.00

Cust Item ID: **Customer:** 

Required Date: 7/26/2011

Reference:

Process Plan: \\

**Tooling:** 

Date:

Run

Start

Stop

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

**Operation** Description

Req'd Qty: 2.00

Set Up/ **Run Hours**  Tool ID

Tool # Plan Accept Qty Code

Reject Qty

Reject Number

Stamp

**Draw Nbr** 

**Revision Nbr** 

D3463 Rev B

100

Large Fab Large Fab

Large Fab

Memo

Memo

0.00

0.00

Weld assembly as per dwg D3463 using DT8875

EZ 11-8-29



110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Quality Control

120

QC

Dart Aerospace Lt	a	
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W/O:	<u> </u>		14	AND OPPED OUT AND		·····			<del> </del>
W/O:			V	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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								<del></del> :	*********
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Part No	·	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQ	A:	Date: _	·
	R	esolution:	Disposit	ion:	_ QA: N/C CI	osed:		Date:	
NCR:		\	WORK OR	DER NON-CONFORMA	ANCE (NCF	R)			
DATE	STEP	Description of NC	Initial		tion B Verif		erification Appro		Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector
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Monday, August 29, 2011 10:44:56 AM

Item ID:

D3463-041

Accept

Revision ID:

Item Name:

Step Weldment Assembly

**Start Date:** 

7/19/2011

Start Qty: 2.00

Required Date: 7/26/2011

Req'd Qty: 2.00



Reference:

**Approvals:** 

Date:

**Tooling:** 

0.00

QC:

Date:

SPC (Y/N):

Sequence ID/

**Work Center ID** 

**Operation** Description Set Up/ **Run Hours** 

130

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Wing Walk as per dwg QSI005 4.4 Batch M 118 3 1 3.00

HandFinish

140

150

Memo

0.00

Hand Finishing

QC3- Inspect Part Finish

Memo

0.00

Quality Control

Run

Setup Start

Stop



Cust Item ID: **Customer:** 

Date:

Date:

Start

Stop

Tool ID

Tool # Plan Code

Accept Oty

Reject Reject Qty Number

Insp. Stamp

4 BL 119-1.

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W/O:			WC	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:			_ NC	R: Yes N	lo <b>DQ</b> /	A:	Date: _	
	R	esolution:	Dispositio	1:	QA	: N/C Clo	sed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC			ction B		Verific	ation	Approval	Approval
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Monday, August 29, 2011 10:44:56 AM



Page 3

Item ID:

D3463-041

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Step Weldment Assembly

Start Date: **Required Date: 7/26/2011** 

7/19/2011

Start Qty: 2.00

Req'd Qty: 2.00



Cust Item ID:

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Reject

Number

Sequence ID/ **Work Center ID** 

160



Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location: 51

Tool ID Set Up/

Run Hours

Code

Tool # Plan

Reject

Qty

Accept

Qty

170

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W/O:			V	WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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		esolution:											
NCR:			WORK OR	DER NON-CONFORMA	NCE (NCR	1)							
DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval				
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		ion C	Chief Eng	QC Inspector				
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### **Picklist Print**

Monday, August 29, 2011 10:44:53 AM

Work Order ID: 72201

Parent Item:

D3463-041

Parent Item Name: Step Weldment Assembly



Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV. A 05.11.18 new issue

with wing walk DD 10.01.28 verified by:EC

IPP revB: replace pressure EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-806 SS DOWEL PIN 1" LONG		Purchased	No			100	Each	72.0000	2	4 Q		-8-2	3
		,		<u>Location</u> ST		<u>Loc (</u>	72	Loc Code		- <del>2</del>	_		
D3453-3		Manufactured	No	_	117606	100	72 Each	8.0000	1	2 A		8-2%	<b>3</b>
-				<u>Location</u> WA	<del>708</del> 54	<u>Loc (</u>	<u>Qtv</u> 8 2	Loc Code		7	_		
D3453-5		Manufactured	No		<del>719</del> 00	100	6 Each	5.0000	1 	$\frac{\mathcal{F}}{\mathcal{A}}$	- <i>  -</i> 8	-29	). 
				Location WA023		<u>Loc (</u>	<u>Otv</u>	Loc Code			- 4	(	
D3463-1		Manufactured	No		59204	100	5 Each	8.0000		2 12	4	11-8-0	75
				<u>Location</u> WA	_	Loc (	<u>Oty</u> 6	Loc Code					
					70855 72034		6 2 2			2	<del>-</del> 		

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W/O:			WC	RK ORDER CHANG	GES				×
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		solution:							
NCR:		-	WORK ORDI	R NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC			ction B		cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector
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### **Picklist Print**

Monday, August 29, 2011 10:44:53 AM

Work Order ID: 72201

Parent Item:

D3463-041

Parent Item Name: Step Weldment Assembly



Start Date: 7/19/2011

Required Date: 7/26/2011

Page 2

Start Qty: 2.00

Required Qty: 2.00

D3463-3

Step

Manufactured

100

Each 16.0000

A 118-29

D3463-5

End Cap

Manufactured

Location 100

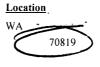
Loc Qty 16 16 Each Loc Code

29.0000

D3463-7 Manufactured



Drag Arm



Loc Qty 29 29 100 Each

5.0000

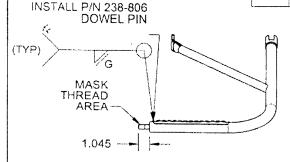
Loc Code

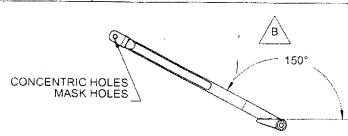
Location 70857 Loc Qty 5 Loc Code

W/O:			W	ORK ORDER CHANG	iES				
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Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:			WORK ORE	DER NON-CONFORM	ANCE (NC	R)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Description	tion B Sign		cation	Approval	Approval
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DESIGN R	•	DRAWN BY RF	DART AEROSPAC HAWKESBURY, ONTARIO,	
CHECK	ED #	APPROVED	DRAWING NO.	REV. B SHEET 1 OF 4
DATE			TITLE :	SCALE
	05.1	2.05	STEP WELDMENT	1:8
Α	0	5.09.20	NEW ISSUE	
В	0:	5.12.05	REVISE DIM.; D3463-5 WAS D34	63-5F



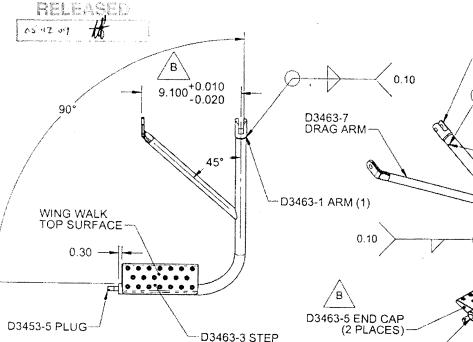


**D3453-3 CLEVIS** 

**INSTALL SPAENAUR** 

P/N'238-806 DOWEL PIN

(TYP)



(2 PLACES) D3463-042 STEP WELDMENT ASSEMBLY

### NOTES:

**D3463-041 OPPOSITE** 

- 1) WELD PER DART QSI 004
  2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
  BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
  3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) ALL DIMENSIONS ARE IN INCHES
  5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
  6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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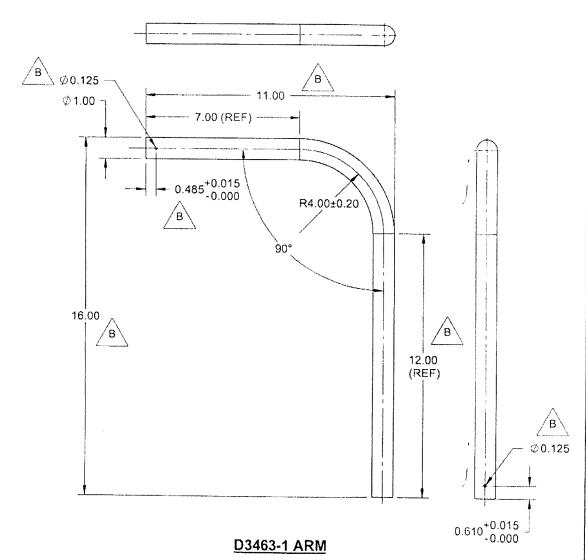
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DATE	STEP	PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC							
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CHECKED 1/L	APPROVED	DRAWING NO.	REV. B
10		D3463	SHEET 2 OF 4
DATE		TITLE	SCALE
05.	12.05	STEP WELDMENT	1:4





### NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
  2) FINISH: NONE
  3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) ALL DIMENSIONS ARE IN INCHES
  5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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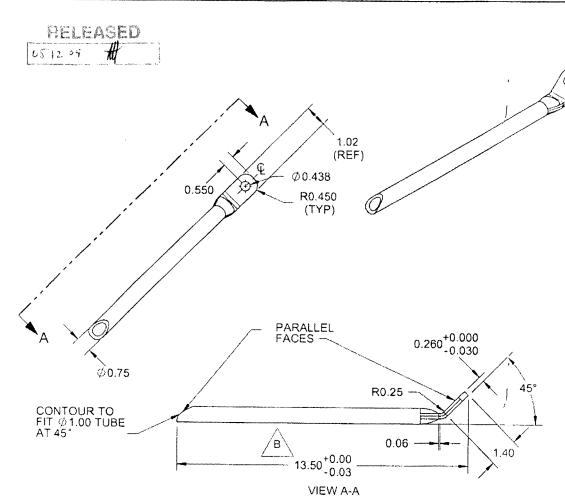
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DATE	STEP	STEP Description of NC Section A	Corrective Action Section B			Verification			1 Approval	Approval			
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DATE 05.	12.05	TITLE STEP WELDMENT	SCALE 1:4				



## **D3463-7 DRAG ARM**

#### NOTES:

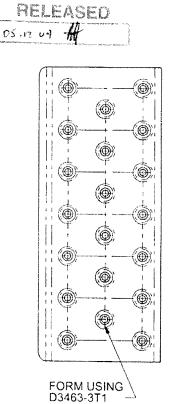
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
  2) FINISH: NONE
  3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) ALL DIMENSIONS ARE IN INCHES
  5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

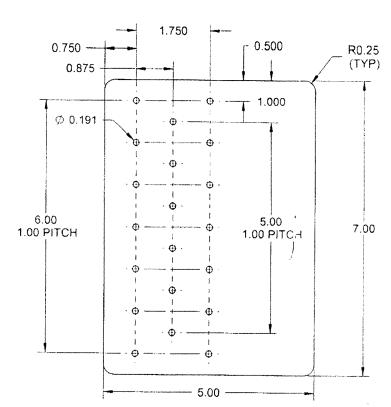
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Fail NO			Fault Category: NCR: Yes No DQA: Disposition: QA: N/C Closed:							
NCR:				R NON-CONFORM						
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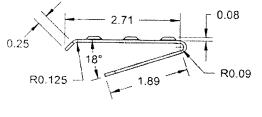


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DATE 05.1	12.05	STEP WELDMENT	SCALE 1:2				

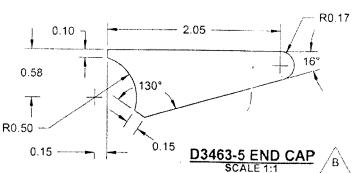




# **D3463-3F FLAT PATTERN**



**D3463-3 STEP** 



#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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Part No:		PAR #:	Fault Cat	Fault Category: NCR: Yes No DQA:						
Resolution:			Disposition: Q			A: N/C Closed: Date:				
NCR:		V	VORK ORI	DER NON-CONFOR	RMANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Section E			Sign &	Verific			Approval
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